

Work Order ID 71355

Wednesday, June 29, 2011 10:55:23 AM



Page 1

Item ID: D2649

Accept



Setup Start



Revision ID:

Item Name: Cross Bolt Spacer

Stop



Start Date: 6/29/2011 Start Qty: 200.00



Cust Item ID:

Required Date: 7/4/2011 Req'd Qty: 200.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date:

6-29-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2649	Rev B1

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per folio FA214 on cobra machine.

SL 11/7/4

202 6

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11/7/4

202 6

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

ant 11/07/04

202 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries



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Page 2

Item ID: D2649 Accept  Setup Start 
Revision ID: Stop 
Item Name: Cross Bolt Spacer
Start Date: 6/29/2011 Start Qty: 200.00  Cust Item ID:
Required Date: 7/4/2011 Req'd Qty: 200.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125  Skidtubes	Memo	0.00							
Skidtubes	1- clean crossbolt spacer with ultra brigh aluminum cleaner before storing.	0.00							
130  Packaging	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
Packaging	Memo	0.00							
	STOCK IN SKIDTUBE CELL								
140  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

*202# 0 BE11/07/04

*202# 0 BE11/07/04

11/7/59
YME 11-07-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Wednesday, June 29, 2011 10:55:38 AM

Page 1

Work Order ID: 71355

Parent Item: D2649

Parent Item Name: Cross Bolt Spacer



Start Date: 6/29/2011

Required Date: 7/4/2011

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP F 02.03.26 Added turning on Cobra NG added cleaning DD verified :EC
IPP Rev:G 10.05.11

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T0.375W.058

Purchased

No

100

f

243.5480

0.2833

59.64211



11/7/14

6061-T6 RD Tube .375 x.058W

Location

Loc Qty

Loc Code

MAT014

243.548

115901

7.9

116920

0.578

117598

235.07

58 ft

W/O:		WORK ORDER CHANGES					
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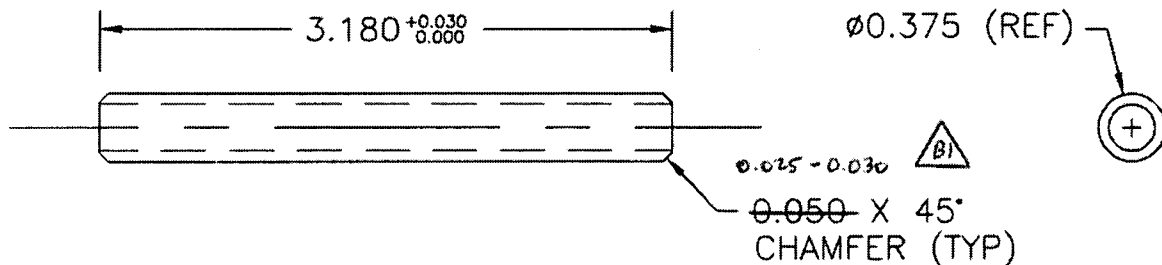


DESIGN <i>DM</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DM</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
BI	CP 02.06.13	REDUCE CHAMFER PER TSR 1296.	

RELEASED
98.01.20 DS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71355

PH-06-29



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.375 DIA 0.058 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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